

Work Order ID 68476

Thursday, April 14, 2011 8:58:58 AM



Page 1

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 4/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11/04/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

21/5/12

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/5/12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 11/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68476

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Page 2

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Start Date: 4/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

0.00

Packaging

Memo

Identify and Stock in Kanban Location: MAT 060

DL 11/05/05

140

0.00



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

11/5/05

MP
11-05-05

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 8:59:06 AM

Page 1

Work Order ID: 68476



Parent Item: DSK078



Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 4/14/2011

Required Date: 4/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-005

Manufactured No

Each

5.0000

10



Round Billet, 17-4

5/11/12

Location

Loc Qty

Loc Code

MAT047

5

65956

5

5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	684/76
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.953	4.963	4.955	4.955	4.955
C	3.064	3.084		3.073	3.074	3.074	3.074	3.073
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.107	.100	.100	.101	.101
F	2.934	2.954		2.943	2.944	2.943	2.944	2.944
G	2.166	2.186		2.177	2.177	2.177	2.177	2.177
H	3.890	3.910		3.903	3.903	3.930	3.903	3.903
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.031	.032	.031	.031	.031
K	0.109	0.129		.118	.118	.118	.117	.118
L								
M								
N								
O								
P								

Measured by: W Date: 11/5/12

Audited by: SL Date: 11/05/05

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>[Signature]</u>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

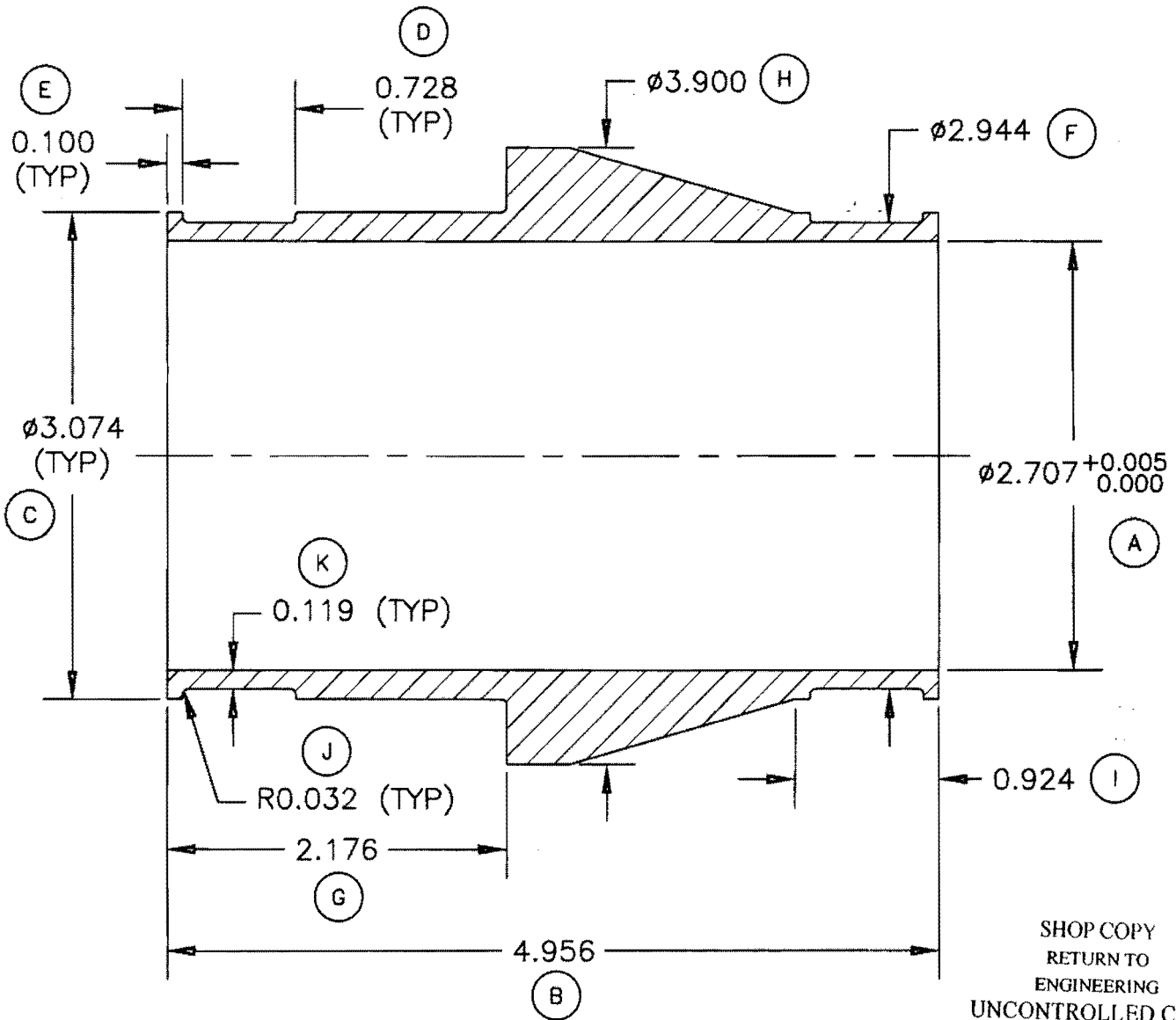
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68474

D2893-1 TURNING DETAIL

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